

NO. 907903B

OPERATORS' MANUAL & REPAIR PARTS LIST

4-1/4" X 6" COMBINATION CUT-OFF BAND SAW

study carefully before operating



Models 3002
3003

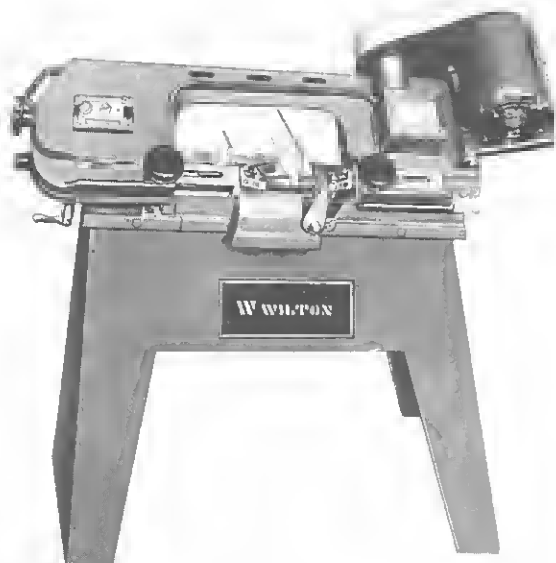


Wilton Corporation/Machinery Division

For Special Service, contact your Wilton Dealer or Machinery Service,
Des Plaines, IL 60018, Telephone Number 312/827-7700.

BANDSAWS

Model 3002 — Horizontal/Vertical Floor Model
Model 3003 — Horizontal/Vertical Bench Model



MODEL 3002
HORIZONTAL/VERTICAL
BANDSAW — Floor Model

GENERAL

You have purchased a quality Wilton product which deserves good care. Familiarize yourself with the entire contents of this publication for maximum satisfaction from the use of the machine.

UNPACKING

Check your Wilton Bandsaw thoroughly, for concealed shipping damage immediately upon unpacking. If damage has occurred, claims should be filed with the delivery carrier for fastest action. Filing with the dealer or manufacturer will result in a delay.

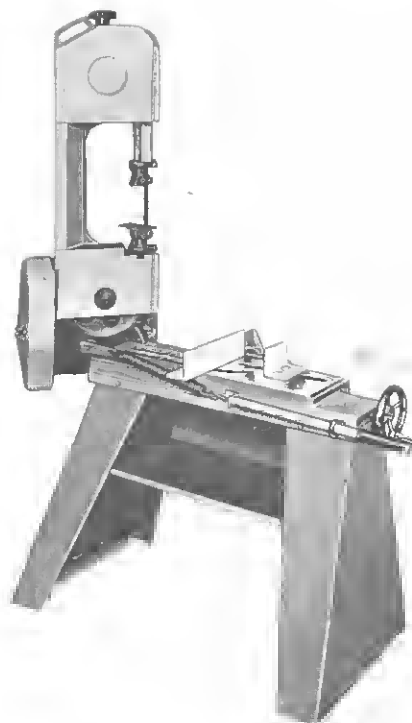
MOUNTING

The saw may be mounted on your own bench or stand. The rear end of the base must be mounted flush with the rear of the stand or bench to permit vertical operation for Model 3003 Bandsaw.

*Model 3002 comes complete with floor stand.

GENERAL SAFETY INFORMATION

1. This unit is equipped with a three prong (grounding) plug for your protection against shock hazards and should be plugged directly into a properly grounded three prong receptacle. Where a two prong wall receptacle is encountered, it must



be replaced with a properly grounded three prong receptacle in accordance with the National Electrical Code and Local Codes and Ordinances. **THIS WORK SHOULD BE DONE BY A QUALIFIED ELECTRICIAN.** A grounding adapter may be used. The green lead or terminal on side of adapter should be securely connected to a suitable electrical ground such as a grounded water pipe, or properly grounded metallic raceway, or ground wire system. **DO NOT** cut off the round grounding prong!

2. The use of 3-prong adapters in CANADA is prohibited by the Canadian Electrical Code!

3. Use only 3-wire extension cords which have 3-prong grounding type plugs.

4. Replace or repair damaged or worn cord immediately.

5. Keep guards in place and in working order.

6. Remove adjusting keys and wrenches. Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.

7. Keep work area clean. Cluttered areas and benches invite accidents.

8. Avoid dangerous environment. Don't use power tools in damp or wet locations. Keep work area well lit.

9. All visitors should be kept safe distance from work area.

10. Make workshop child proof — with padlocks, master switches, or by removing starter keys.

11. Don't force tool. It will do the job better and safer at the rate for which it was designed.

12. Use right tool. Don't force tool or attachment to do a job it was not designed for.

13. Wear proper apparel. No loose clothing or jewelry to get caught in moving parts. Rubber-soled footwear is recommended for best footing.

14. Use safety glasses. Also use face or dust mask if cutting operation is dusty.

15. Secure work. Use clamps or a vise to hold work when practical. It's safer than using your hand and it frees both hands to operate tool.

16. Don't overreach. Keep proper footing and balance at all times.

17. Maintain tools with care. Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

18. Disconnect power before servicing; when changing accessories such as blades, bits, cutters, etc.

19. Avoid accidental starting. Make sure switch is in "Off" position before plugging in.

20. Never leave the machine running unattended.

21. Never brush away chips while the machine is in operation.

22. Use only recommended accessories and follow manufacturer's instructions pertaining to them.

23. Do not attempt any make shift field repairs. Call maintenance for proper servicing.

24. KNOW THE TOOL YOU ARE USING, ITS APPLICATIONS AND LIMITATIONS.

MOTOR SPECIFICATION AND INSTALLATION

A 1/3 hp, 1725 rpm motor is standard. Counter clockwise rotation is required. Note that rotation can be reversed by following the directions given on the terminal or nameplate.

INSTALL THE MOTOR AS FOLLOWS:
(If non motorized See Fig. 3.)

1. Assemble the Motor Mounting Plate (Ref. 55) to the Head (Ref. 27) using the long Bolt (Ref. 60). Note that the flat side of the Plate faces up.

2. Assemble the Guard Plate (Ref. 9) to the Head (Ref. 27) using the Screw (Ref. 12) and Lock Washer (Ref. 11), Carriage Bolt (Ref. 57) Washer (Ref. 20) and Wing Nut (Ref. 19). The Screw goes into the Casting while the Carriage Bolt, Washer, and Wing Nut are used to secure the Motor Mounting Plate to the Guard Plate through the slotted hole in the Guard Plate. These components also serve to position and lock the Motor in place for proper speed belt adjustment.

3. Place the Spacer (Ref. 14) over the long bolt (Ref. 60) and secure it with the Nut (Ref. 15).

4. Secure the Motor to the Motor Mounting Plate (Ref. 55) with the four Bolts (Ref. 59) and Nuts (Ref. 56). Note, that the Motor Shaft is placed through the large opening in the Guard Plate and must be parallel with the Drive Shaft (Ref. 67).

5. Assemble the Motor Pulley (Ref. 21), the smaller of the two provided, to the motor shaft. Note, the smallest diameter must be closest to the motor. Do not tighten the set screw.

6. Assemble the Driven Pulley (Ref. 10), the larger of the two provided, to the protruding Drive Shaft (Ref. 5). Note, the larger diameter must be closest to the bearing. Do not tighten the setscrew.

7. Place the Belt (Ref. 13) into the smaller diameter of the Driven Pulley (Ref. 10), and onto the larger diameter of the Motor Pulley (Ref. 21).

8. Line up the Belt and both Pulleys such that the Belt is running parallel in the Pulley grooves.

9. Tighten the setscrews of both Pulleys in this position.

10. Place the Belt into proper pulley combination for desired blade speed. See "Blade Speed" chart on Page 4.

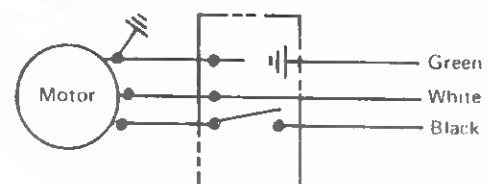
11. Adjust the position of the Motor to obtain approximately 1/2" depression in the belt when applying pressure with your thumb.

12. Tighten the Wing Nut holding the Motor Mounting Plate to the Guard Plate.

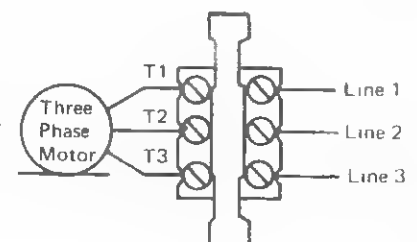
13. Assemble the Pulley Guard (Ref. 16) to the Guard Plate using the Wing Nut (Ref. 17) and the Washer (Ref. 18).

14. Connect the Switch Assembly (Fig. 4, Ref. 17), Cord Set (Fig. 3, Ref. 1) and Motor at the motor terminal box as per the proper schematic (as shown below).

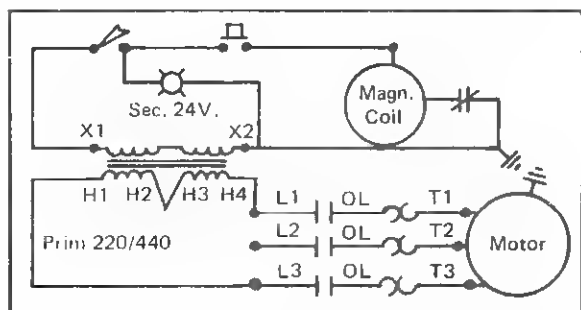
Single Phase Motor



Three Phase Motor



Three Phase Motor with 24 Volt Switch



NOTE: The motor should be protected with a time delay fuse or circuit breaker with a rated amperage slightly greater than the full load current of the motor. See individual motor name plates.

WORK SET UP

1. Raise the saw head to the vertical position.
2. Open the vise to accept the piece to be cut by rotating the wheel at the end of the base (counterclock wise).
3. Place the workpiece on the saw bed. If the piece is long, support the end.
4. Clamp the workpiece securely in the vise by rotating the hand wheel clockwise.

WORK STOP ADJUSTMENT—See Fig. 4

1. Loosen the wing bolt (Ref. 28) holding the work stop casting (Ref. 19) to the shaft (Ref. 18).
2. Adjust the work stop casting to the desired length position.
3. Rotate the work stop as close to the bottom of the cut as possible.
4. Tighten the Wing Bolt (Ref. 28).
5. **DO NOT ALLOW** the blade to rest on the work while the motor is shut off.

CONVERTING FOR VERTICAL USE— See Fig. 3

Notching, slitting, contour work may be done with the saw in the vertical position in the following manner.

1. Rotate the head to the vertical position.
2. Remove machine screws (Ref. 51), and deflector plate (Ref. 52).
3. Assemble the 503961 10" x 10" table (an option that may be purchased from your dealer) to the guide bar using the screws provided.

BLADE SPEEDS

When using your Wilton Bandsaw always change the blade speed to best suit the material being cut. The chart below gives suggested settings for several materials.

Material	Speed	Belt Groove Used	
		Motor Pulley	Driven Pulley
Tool, Stainless or Alloy Steel, Bearing Bronzes	65 FPM	Small	Large
Mild Steel, Hard Brass or Bronze	120 FPM	Medium	Medium
Soft Brass, Aluminum, Other light materials	220 FPM	Large	Small

BLADE DIRECTION OF TRAVEL

Be sure the blade is assembled so that the vertical edges of the teeth engage the work first as the blade moves in a clockwise direction around the pulleys when the saw is in an upright position. See Fig. 2

BLADE MOVEMENT



Fig 2.

CAUTION: Never operate Saw without Blade Guards in Place.

Be sure the blade is not in contact with the work when the motor is started. Start the motor, allow the saw to come to full speed, then begin the cut by letting the head down slowly onto the work. **DO NOT DROP OR FORCE.** Let the weight of the saw head provide the cutting force. The saw automatically shuts off at the end of the cut.

RATE OF FEED

The rate of feed is pre-set at the factory to its lowest level. To increase the feed, turn the feed screw adjustment (at left of base) counterclockwise; to decrease, turn clockwise. Do not adjust more than one turn at a time. Proper feed is important; excessive pressure can break the blade or stall the saw. Insufficient pressure dulls the blade rapidly.

BLADE SELECTION

SPECIAL NOTE: A (1/2" x .025 x 64-3/4) min. 65-1/2 max.) 14 tooth per inch general use blade is furnished with the Wilton Metal Cutting Bandsaw. Additional blades in 6 (#503459), 10 (#503460) and 14 (#503452) tooth sizes are available. The choice of blade pitch is governed by the thickness of the work to be cut: the thinner the workpiece, the more teeth advised. A minimum of 3 teeth should be in the workpiece at all times for proper cutting. If the teeth of the blade are so far apart that they straddle the work, severe damage to the workpiece and to the blade can result.

CHANGING BLADES—See Fig. 3

Raise the saw head to vertical position and remove screws (Ref. 75). Open wheel guard assembly door (Ref. 77). Loosen socket head screw (Ref. 37), swing blade guard (Ref. 3B) so that blade will clear. Loosen blade tension screw knob (Ref. 2B) to sufficiently allow saw blade to slip off of wheel. Install new blade with the vertical edge of the tooth entering the work first so that the blade will cut when rotating in a clockwise direction.

1. Place the blade in between each of the guide bearings (Ref. 40 & Ref. 41).

2. Place blade around drive wheel (Ref. 72) with right hand and hold in position. Hold blade against the outer diameter drive pulley and pull blade upward, slipping blade over upper idler wheel (Ref. 25). Push blade firmly against back shoulder of wheels.

3. Adjust the blade tension knob clockwise until it is just tight enough so no blade slippage occurs. Do not tighten excessively.

4. Replace the blade guards in position and secure in place with screw (Ref. 75) previously removed.

BLADE GUIDE BEARING ADJUSTMENT

This is the most important adjustment on your saw. It is impossible to get satisfactory work from your saw if the blade guides are not properly adjusted.

The blade guide bearings on your Wilton Metal Cutting Bandsaw are adjusted and power-tested with several test cuts before leaving the factory to insure proper setting. The need for adjustment should rarely occur when the saw is used properly. If the guides do get out of adjustment, it is extremely important to readjust immediately. If improper adjustment is maintained, the blade will not cut straight and if the situation is not corrected it will cause serious blade damage.

Because guide adjustment is a critical factor in the performance of your saw, it is always best to try a new blade to see if this will correct poor cutting performance before beginning to adjust. If a blade becomes dull on one side sooner than the other, for example, it will begin cutting crooked.

A simple blade change will correct this problem — the more difficult guide adjustment will not.

If a new blade does not correct the problem, check the blade guides for proper spacing.

There should be .000 (just touching)—.001 clearance between the .025 thickness blade and guide bearings.

To obtain this clearance adjust as follows:

1. The inner guide bearing is fixed and cannot be adjusted.

2. The outer guide bearing is mounted to an eccentric bushing and can be adjusted.

3. Loosen the nut while holding the bolt with an Allen wrench.

4. Position the eccentric by turning the bolt to the desired position of clearance.

5. Tighten the nut.

6. Adjust the second blade guide bearing in the same manner.

BLADE GUIDE BEARING ASSEMBLY VERTICAL ADJUSTMENT

The back edge of the blade should just touch the ball bearing in the Blade Guide Bearing Assembly. To adjust proceed as follows:

1. Loosen the Cap Screw (Ref. 43) holding the Blade Guide Bearing Assembly (Ref. 53 & 39) to their respective Guide Bars (Ref. 47 & 54).

2. Position each Blade Guide Bearing Assembly to where the ball bearing just touches the back edge of the blade by sliding the assembly up/down.

3. Lock the assemblies in position by tightening the Cap Screw previously loosened.

BLADE GUIDE ASSEMBLY ADJUSTMENT

The Wilton Metal Cutting Bandsaw is equipped with two adjustable blade guide assemblies. This feature will permit you to adjust the position of the blade guides for various widths of workpieces.

To effect the most accurate cut and prolong the life of the blade, the blade guide assemblies should be adjusted to just clear the piece to be cut. This is done as follows:

1. Place the workpiece in the vise of the saw and clamp tightly.

2. Adjust each blade guide assembly to the desired position by loosening the hand knobs and positioning the guides as required.

3. Tighten the hand knobs.

BLADE TRACKING ADJUSTMENT

This adjustment has been completed and power-tested at the factory. The need for adjustment should rarely occur when the saw is used properly. If the tracking goes out of adjustment, the blade will leave the pulley and damage will result. Adjust the tracking as follows.

1. Remove screws (Ref. 75) from guard door.

2. Open blade cover assembly (Ref. 77).

3. Loosen blade tensioning screw (Ref. 2B) to where the blade is just touching pulley.

4. Loosen hex head screw (Ref. 34) (middle screw in block assy.) in pulley shaft to a point where it is loose but snug.

5. Adjust set screw (Ref. 35) to pivot pulley in desired direction to obtain the following:

(a) The back side of the blade should just touch the shoulder of the pulley and

(b) The back side of the blade should just touch the ball bearing guide in each of the blade guide assemblies.

6. Tighten the blade tension screw (Ref. 28).

7. Tighten the hex head screw in the pulley shaft (Ref. 33).

8. Turn the saw on for a moment or two to allow the blade to "seat" itself.

9. Check the adjustments as noted in item 5 above.

10. If the adjustments are not correct and the blade does not track properly repeat the procedure as many times as required to effect proper operation.

11. When proper tracking has been completed replace the blade cover assembly (Ref. 77).

3. After installing a new blade, check tension after a few strokes.

4. For correct blade tension, snap your finger against the blade. A slight "ring" will sound if blade tension is correct.

5. Generally it can be said that the harder the material the slower the cutting speed should be.

6. Most blade manufacturers have developed charts and specifications to determine the best blade for cutting various kinds and shapes of materials. **USE THESE**, however as a general rule the thinner the stock, the finer the tooth pitch. Use the coarsest pitch possible consistent with the above. Also, **REMEMBER — A MINIMUM OF THREE TEETH MUST CONTACT MATERIAL AT ALL TIMES.**

7. Secure stock properly.

NOTE: FOR DETAILED CUTTING DATA, CHECK WITH YOUR MACHINIST HANDBOOK.

LUBRICATION

Lubricate the following components using SAE 80 oil as noted.

1. Ball bearing - none.

2. Blade guide bearing - none.

3. Driven pulley bearing - 6-8 drops a week.

4. Vise lead screw - as needed

5. The drive gears run in an oil bath and will not require a lubricant change more often than once a year, unless the lubricant is accidentally contaminated or a leak occurs because of improper replacement of the gear box cover. During the first few days of operation, the worm gear drive will run hot. Unless the temperature exceeds 200 °F., there is no cause for alarm.

The following lubricants may be used for the gear box:

Atlantic Refinery Co. — Mogul Cyl. Oil
Cities Service — Optimus No. 6
Gulf Refinery Co. — Medium Gear Oil
Pure Oil Co. — Park Clipper
Richfield Oil Co. — Richfield Cyl. W.S.
Shell Oil Co. — Shell Valvata Oil
No. J-78 or Macoma 72

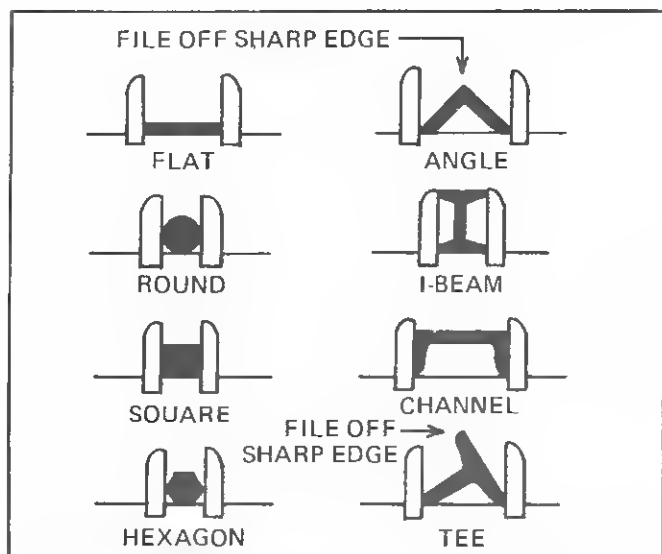


Figure 5 — Properly Securing Stock in Vise

HELPFUL CUTTING HINTS

1. Never use a new blade to complete previously started cut.

2. Where possible, do not start a cut on sharp corners.

TROUBLE SHOOTING

Problem	Probable Cause	Solution
Excessive Blade Breakage	Material loose in vise Incorrect speed or feed Teeth too coarse for material Incorrect blade tension Teeth in contact with work before saw is started Blade rubs on wheel flange Misaligned guides Blade too thick for wheel diameter Cracking at weld	Clamp work securely Check Machinist Handbook Check Machinist Handbook for recommended blade type Adjust to where blade just does not slip on wheel Place blade in contact with work after motor is started Adjust wheel alignment Adjust Use thinner blade Make longer annealing cycle
Premature Blade Dulling	Teeth too coarse Too much speed Inadequate feed pressure Hard spots or scale in/on material Work hardening of material (especially stainless steel) Blade installed backwards Insufficient blade tension	Use finer tooth blade Try next lower speed Decrease spring tension on side of saw Reduce speed, increase feed pressure (Scale) Increase feed pressure (Hard Spots) Increase feed pressure by reducing spring tension Remove blade, twist inside out and reinstall blade Increase tension to proper level
Bad Cuts (Crooked)	Work not square Feed pressure too great Guide bearings not adjusted properly Inadequate blade tension Blade guides spaced out too much Dull Blade Speed incorrect Blade guide assembly loose Blade guide bearing assembly loose Blade tracks too far away from wheel flanges	Adjust vise to be square with blade Always clamp work tightly in vise Reduce pressure by increasing spring tension on side of saw Adjust guide bearings to .002 greater than max. thickness, including weld, of the saw Increase blade tension a little at a time Move guides as close to work as possible Replace blade Check manual for recommended speeds Tighten Tighten Retrack blade according to operating instructions
Bad Cuts (Rough)	Too much speed or feed Blade is too coarse	Reduce speed and feed Replace with finer blade
Blade is Twisting	Cut is binding blade Too much blade tension	Decrease feed pressure Decrease blade tension
Unusual Wear on Side/Back of Blade	Blade guides worn Blade guide bearings not adjusted properly Blade guide bearing bracket is loose	Replace Adjust as per operators manual Tighten
Teeth Ripping from Blade	Tooth too coarse for work Too heavy feed, too slow feed Vibrating work piece Gullets loading	Use finer tooth blade Increase feed pressure and/or speed Clamp work securely Use coarse tooth blade or brush to remove chips
Motor Running Too Hot	Blade tension too high Drive belt tension too high Blade is too coarse for work (Pipes especially) Blade is too fine for work (Heavier, soft material) Gears not aligned properly Gears need lubrication Idler wheel needs lubrication	Reduce tension on blade Reduce tension on drive belt Use finer blade Use coarser blade Adjust gears so that worm is in center of gear Check oil bath Oil bearing/shaft on idler wheel

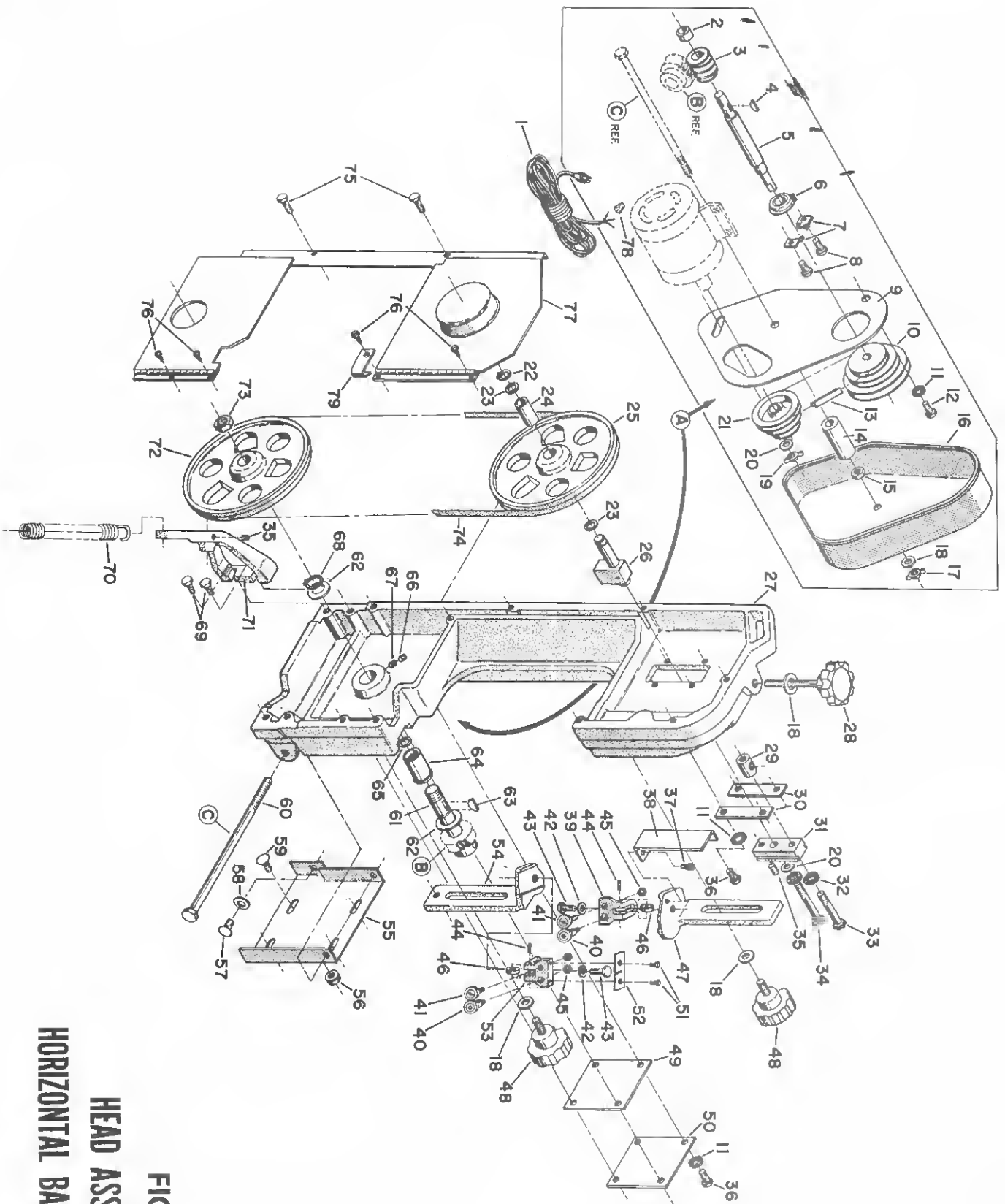


FIG. 3

HEAD ASSEMBLY
HORIZONTAL BANDSAW

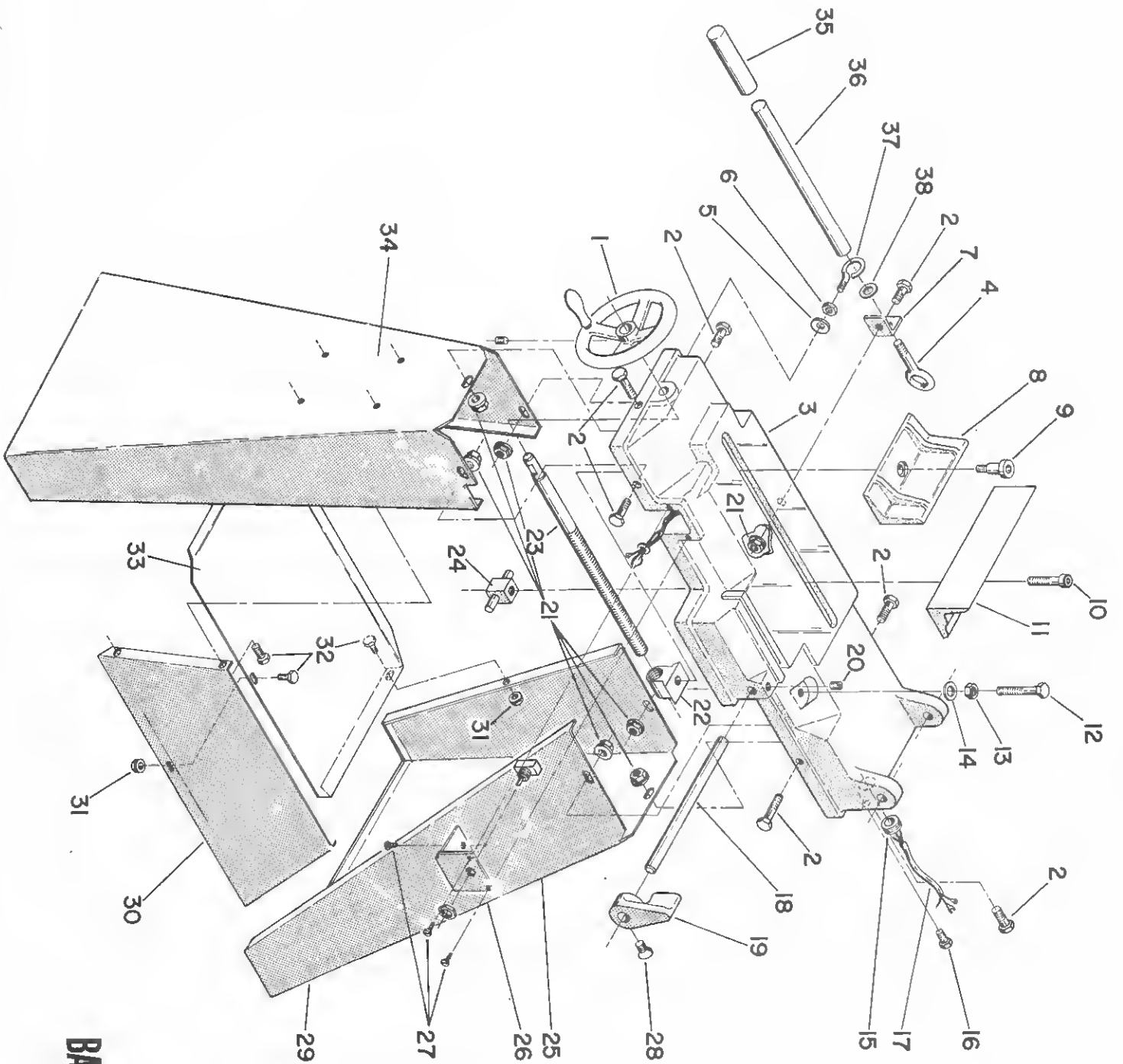


FIG. 4
BASE ASSEMBLY

**4 1/4" x 6" COMBINATION CUT-OFF BAND SAW
PARTS LIST (See Fig. 3)**

Item No.	Part No.	Description	Qty. Req'd
1	911949	Cord Set	1
2	910503	Bearing 1/2 x 3/4 x 1/2	1
3	503445	Worm	1
4	911446	Woodruff Key	1
5	503487	Drive Shaft	1
6	910037	Bearing	1
7	503777	Bearing Retainer	2
8	905081	Mach. Screw 1/4 - 20 x 1/2	2
9	503417	Guard Plate	1
10	911510	Driven Pulley	1
11	905831	L Washer	9
12	905102	Mach. Scr. 1/4 - 20 x 1/2	1
13	911674	"V" Belt	1
14	503430	Spacer	1
15	905699	Hex. Nut 3/8 - 16	1
16	503440	Pulley Guard	1
17	905701	Wing Nut 3/8 - 16	1
18	905730	Washer	4
19	905707	Wing Nut 5/16 - 18	1
20	905751	Washer	2
21	911509	Motor Pulley	1
22	905357	Retaining Ring	1
23	903991	Washer	2
24	910504	Bearing	1
25	503403	Idler Wheel	1
26	503919	Idler Wheel Shaft Assy.	1
27	503401	Head Casting	1
28	503423	Blade Tension Screw Assy.	1
29	503420	Tension Block	1
30	503422	Guide Holder	2
31	503421	Block Guide	1
32	905839	L Washer	2
33	913529	Cap Screw 5/16 - 18 x 1-1/4	1
34	905209	Cap Screw 5/16 - 18 x 3/4	1
35	905454	Set Screw 5/16 - 18 x 1/2	2
36	912819	Cap Screw 1/4 - 20 x 1/2	8
37	905240	Cap Screw 1/4 - 20 x 3/8	1
38	503948	Blade Guard	1
39	503805	Blade Guide Assy. Top	1
40	503803	Top Bearing Bracket	1
41	910507	Cam Eccentric Follower	2
42	910506	Cam Follower	2
43	905768	Washer	2
44	906207	Soc. Cap Screw 1/4 - 20 x 1"	2
45	906057	Dowel Pin	2
46	905635	Hex. Nut 3/8 - 24	4
47	910036	Ball Bearing	2
48	503938	Guide Bar Top	1
49	503434	Guide Lock Screw Assy.	2
50	503433	Gear Cover Gasket	1
51	503432	Gear Cover	1
52	913516	Flat Head Screw #10 - 32 x 5/16	2
53	503539	Deflector Plate	1
54	503804	Bearing Bracket Bottom	1
55	503806	Blade Guide Assy. Bottom	1
56	503939	Guide Bar Bottom	1
57	503431	Motor Mounting Plate	1
58	905711	Lock Nut 5/16 - 18	4
59	912710	Carriage Bolt 5/16 - 18 x 1/2	1
60	905749	Washer	1
61	905623	Carriage Bolt 5/16 - 18 x 3/4	4
62	912818	Cap Screw 3/8 - 16 x 10-1/4	1
63	503483	Drive Shaft Assy	1
64	903992	Shims	2
65	911429	Woodruff Key	1
66	910518	Bearing	1
67	901259	"O" Ring	1
68	905296	Set Screw 5/16 - 18 x 1/4	1
69	912780	Set Screw 5/16 - 18 x 3/4	1
70	907409	Retaining Ring	1
71	913532	Flange Screw 5/16 - 18 x 1"	2
72	913702	Spring-Feed	1
73	503404	Tilt Bracket Casting	1
74	503488	Drive Wheel	1
75	912915	L Nut 3/4 - 16	1
	503452	Blade	1
	912860	Cap Screw #10-24 x 3/8	2

4 1/4" x 6" COMBINATION CUT-OFF BANDSAW

Item No.	Part No.	Description	Qty. Req'd
76	905271	Self Tap. Screw	4
77	503535	Blade Cover Assy	1
78	911933	Wire Nut	1
79	503549	Switch Activator Bracket	1

* Not Shown

**BASE FOR 4 1/4" x 6" CUT-OFF BANDSAW
PARTS LIST (See Fig. 4)**

Item No.	Part No.	Description	Qty. Req'd
1	503546	Lead Screw Wheel	1
2	905213	Cap Screw 5/16 - 18 x 1"	7
3	504150	Base Casting	1
4	913517	Eye Bolt 1/4 - 20 x 2-1/2	1
5	905801	Washer	1
6	905699	Hex Nut 3/8 - 16	1
7	503413	Feed Spring Bracket	1
8	503835	Vise Jaw - Left	1
9	906728	Soc. Head Shoulder Screw	1
10	906218	Soc. Cap Screw 3/8 - 16 x 1-3/4	1
11	503836	Vise Jaw - Right	1
12	905489	Cap Screw 5/16 - 18 x 2-1/2	1
13	905645	Hex Nut 5/16 - 18	1
14	905839	L Washer	1
15	911945	Bushing	1
16	912822	Cap Screw w/Nylock	1
17	503490	Cable & Switch Assy.	1
18	503407	Work Stop Rod	1
19	503406	Work Stop Casting	1
20	905454	Set Screw 5/16 - 18 x 1/2	1
21	905711	L Nut 5/16 - 18	7
22	503405	Nut & Guide Casting	1
23	504154	Vise Lead Screw	1
24	503862	Locking Nut Assy	1
25	911740	Switch	1
26	503856	Switch Mounting Plate	1
27	905271	Self Tap. Scr. #8 - 32 x 3/8	3
28	906804	Thumb Screw	1
29	503461	Right Leg	1
30	504152	Skirt - Front	1
31	905722	L Nut #10 - 32	7
32	912824	Cap Screw #10 - 32 x 5/8	7
33	504153	Utility Shelf	1
34	504159	Left Leg	1
35	503545	Handle Sleeve	1
36	503544	Handle Bar Assy	1
37	913521	Eye Bolt	1
38	905758	Washer	1



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